



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

RBT400313-3
Job Sheet 173593



Part No: RBT400313-3

Job Qty: 2 ea

Part Name: Plate



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 3/5/18

Job Tracking No:

Due Date: 3/16/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG RBT400313 Rev 1 IPP Rev A 18.02.26 New issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Start up Operation	2 Ea		3/15/18	0.00	0.00	Start Up Waterjet2		2C 18/03/09
110	Waterjet	2 pcs		3/15/18	0.00	0.20	Waterjet 2 OMAX		2C 18/03/09
120	QC	2 pcs		3/15/18	0.00	0.00	QC2 Waterjet-2		2C 18/03/09
125	HandFinish	2 pcs		3/15/18	0.00	0.00	HandFinish7		BEB 18-03-12
130	Mill Conv	2 pcs		3/15/18	0.00	0.50	Mill Conv 2		2C 18/03/09
140	QC	2 pcs		3/15/18	0.00	0.00	QC2 Machining-4		2C 18-03-14
150	QC	2 pcs		3/15/18	0.00	0.00	QC8 Machining-3		2C 18-03-21
160	Small Fab	2 pcs		3/15/18	0.00	0.20	Small Fab-7		2C 18/03/09
170	Mill Conv	2 pcs		3/16/18	0.00	0.20	Mill Conv 1		2C 18/03/09
180	QC	2 pcs		3/16/18	0.00	0.00	QC2 Machining-4		2C 18/03/09
190	QC	2 pcs		3/16/18	0.00	0.00	QC8 Machining-4		2C 18-03-04
200	Packaging	2 pcs		3/16/18	0.00	0.00	Packaging3-1		2C 18/03/09
210	QC21-SA	2 Ea		3/16/18	0.00	0.00	QC21		2C 18/03/09

Part Op 100 -

Descriptions: 110 - 1-Cut as per Dwg Dwg Rev: / Prog Rev: / 2-Deburr if necessary

125 - Remove scale

130 - Machine as per DWG

140 - Engrave T/N and/or P/N number using Marktronic engraver as per DWG.

160 - Install -11 dowel pin

170 - Mill -11 dowel pin height to meet 0.090" as per note 3 sheet 2 and detail A-A sheet 1.

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
MT-HRS-P-0.250	Hot Rolled Steel Plate 0.250" (44W)	.1820 ft (.091 ea)	100-Start up Operation	
90145A471	Dowel Pin	2 Ea (1 ea)	160-Small Fab	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Start up Operation	MT-HRS-P-0.250	0	0	0
160-Small Fab	90145A471	2	0	0

Part Specifications

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____ Date : _____ _____ _____	DISPOSITION Rework ☐ Scrap ☐ Heat-treat ☐	Skid-tube ☐ Machining ☐ Thermoforming ☐	Cross tube ☐ Small Fab ☐ Finishing ☐	Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐	Engineering ☐ Quality ☐ Other ☐
					MRB (QSI042) Approval
					Completed By
					Lead hand / Supervisor Approval Verification
					QC / QA Coordinator Approval

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 1270 Aberdeen Street
 Hawkebury, ON M6A 1K7
 CANADA
 TEL.: 1 613 832-6200
 Email: sales@dartaero.com
 www.dartaero.com

Date: 03/09/18

Container No: S049784

 Part: RBT400313-3
 Job No: 173593
 Serial No/Batch: S049784
 Revision: 1
 Inspector:

Root Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	BUM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
OTHER : _____					

Specifications could not be found.

Plex 3/5/18 12:54 PM Dart.lajeunesse.marie

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

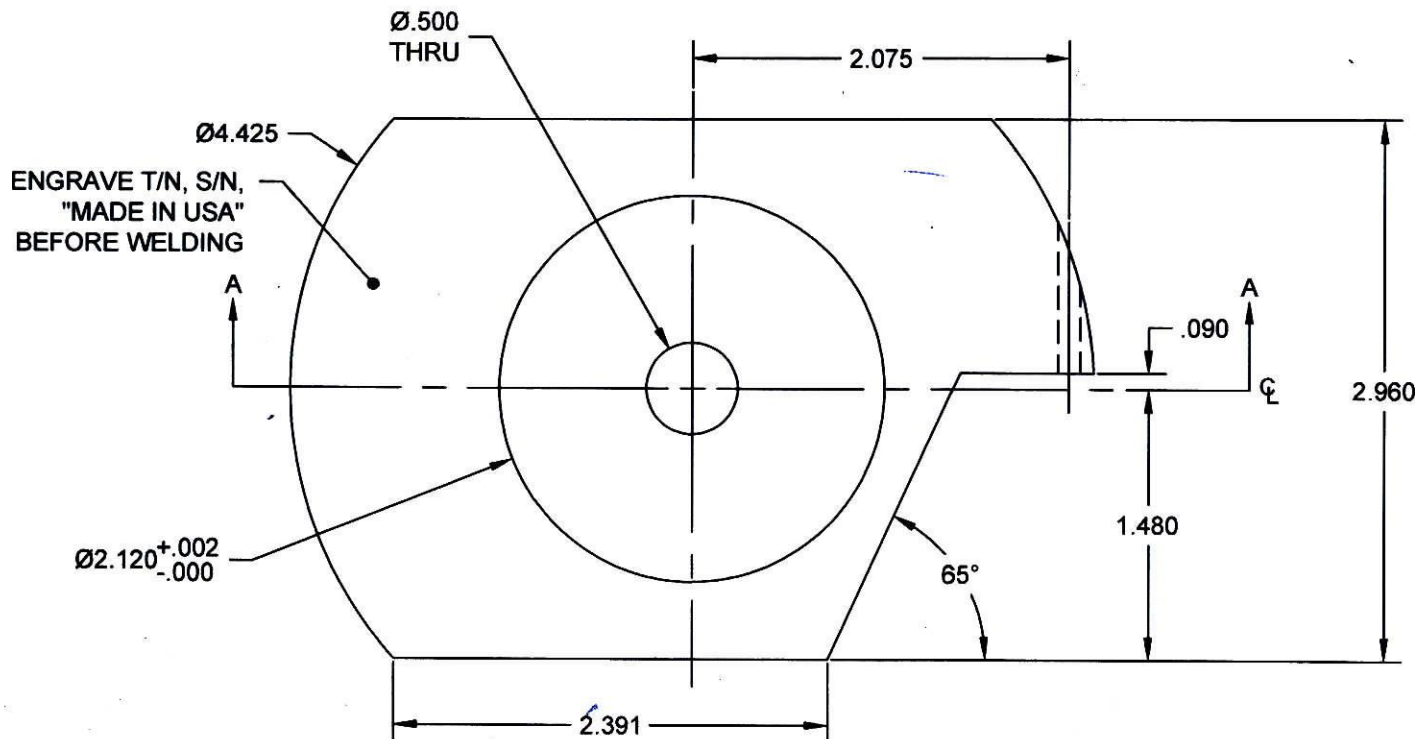
Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width: 100%; border: none;"> <tr> <td style="width: 15%;">Skid-tube ☐</td> <td style="width: 15%;">Cross tube ☐</td> <td style="width: 15%;">Water Jet ☐</td> <td style="width: 15%;">Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Date :		Step #:		QTY Effective :			MRB (QSI042) Approval																		
Description Work Order Deviation				Disposition				Completed By																	
								Lead hand / Supervisor Approval Verification																	
								QC / QA Coordinator Approval																	
Root Cause		FAULT CATEGORY																							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐																				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐																				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐																				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐																				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐																				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐																				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐																				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐																				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐																				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐																				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____																							
Misidentified ☐	Past Due ☐																								

INSPECTION SHEET

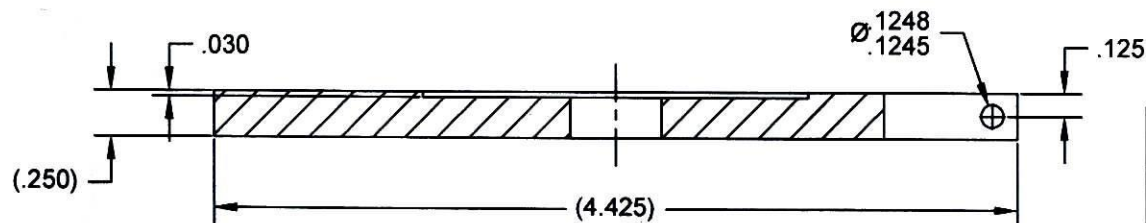
Rev	Date	Change	Revised by	Approved
A	14.07.31	New Issue	KJ	

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REVISIONS				
REV	DESCRIPTION	DATE	INITIAL	APPROVED
A	CORRECTED -3 VIEW ADDED MISSING LINES.	5/16/12	RJC	SE
1	-3 ADDED Ø2.120+0.002-.000 ∇ .030 HOLE, CH'D DIMS WAS .250 IS (.250), WAS (.090) IS .090, WAS (Ø.500) IS Ø.500. ADDED SECTION A-A.	5/12/14	DPD	GE



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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 173593 MLC
1803-05



SECTION A-A

(-3)

PLATE

RED BARN MACHINE	
TITLE MAIN XSMN BACKLASH TOOL	
DWG NO. RBT400313-3	REV 1
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ON: DECIMALS .XXX ± .005 .XX ± .01 .X ± .1 FRACTIONS ± 1/32 ANGLES ± 5°	DRAWN BY: CLOUGH APPROVED: <i>D. Weil</i> HEAT TREAT FINISH SEE -1 WELDMENT SPEC USED ON MODEL BELL 204, 205, 212
UNLESS OTHERWISE SPECIFIED 1. BREAK ALL SHARP EDGES .015 x 45° PR .015 R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING	
SCALE 1:1	DATE 1-7-11
SHEET 3 of 6	

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition			Completed By
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Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
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